

# **ABSTRACT OF THE DISCLOSURE**

Materials and a process are provided whereby polymers with the pendant group or end group containing  $--Si(OR'')_3$  (where  $R''$  is H, an alkyl group, Na, K, or  $NH_4$ ) are used to  
5 control aluminosilicate scaling in a Bayer process. When materials of the present invention are added to the Bayer liquor before the heat exchangers, they reduce and even completely prevent formation of aluminosilicate scale on heat exchanger walls. The present materials are effective at  
10 treatment concentrations that make them economically practical.